

Work Order ID 136764

136764

Page 1

Friday, September 04, 2015 10:05:44 AM

Item ID: D6101-003 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle Billet, 7075
 Start Date: 9/4/2015 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 9/4/2015 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: SEP 04 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D6101	Rev B

100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>29713</u>								
	a) Description: Alluminum billet								
	b) 7.875" x 6.250" x 2.00" thick								
	c) Tolerance on all dimensions are +0.030"/-0.000"								
	d) Grain direction along 7.875" length								
	e) Material: 7075-T7351 (QQ-A-250/12)								
	f) Material certification required								

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								

CZ SEP 08 2015 20
SEP 28 2015 DAS 6 20
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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136764

Page 2

Item ID: D6101-003 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Saddle Billet, 7075
Start Date: 9/4/2015 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 9/4/2015 Req'd Qty: 20.00 ***20*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				20	0		DAS 14 9-89 1509/29
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D6101								
130	Identify as per dwg & Stock Location: MAT045	0.00				20	0		DAS 14 9-89 1509/29
130									
Packaging	Memo	0.00							
Packaging	LOCATION: MAT044								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

SH 20150929

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Friday, September 04, 2015 10:05:47 AM

Page 1

Work Order ID: 136764

136764

Parent Item: D6101-003

D6101-003

Parent Item Name: Saddle Billet, 7075

Start Date: 9/4/2015

Required Date: 9/4/2015

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A: 01.05.04New IssueC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003P		Purchased		No		110	Each	0.0000	1	20			
										**		DAS	
												SEP 28 2015	6 9-89

D6101-003P

7075-T7351 2X6.25X7.875

DQA: _____ Date: _____



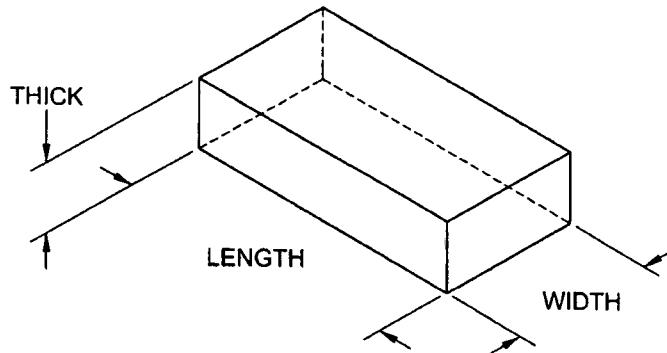
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/W

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NO 13676 YMS
10-60-51

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:2734860

Ship From: A. M. Castle & Co. MONTREAL - CASTLE METALS 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped	F.O.B.	Freight Terms		Carrier		BOL No	
23-SEP-2015	ORIGIN	Prepaid		MANITOULIN		2734860-2	

Shipment Details	Final Destination Branch - MON
-------------------------	---------------------------------------

Order No	Line No	Item No	Description
4050963	1	752237 MO	2.0000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT RECTANGLE TO 6.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 7.875")) X 7.875 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 7.875")) - ALUMINUM PLATE SAW SPECIFICATIONS: AMS-QQ-A-250/12

Purchase Order No	Part Number	Ordered Qty	Invoice Qty
29713	YOUR ITEM NUMBER: D6101-003	20.00 PCS 15/9/28	20.00 PCS

Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S SHIP TO CASTLE, MONTREAL (POINTE-CLAIRE) CUSTOMS BROKER: GEORGE H. YOUNG END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS
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Delivery No.	Mill	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
120180496	KAISER ALUMINUM			20			203.2169

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

These commodities, technology or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to US law prohibited.

Date Printed: 23-SEP-2015 10:54:06 AM



Castle Metals®

A. M. Castle & Co.

**PACKING SLIP/
CERTIFICATE OF CONFORMANCE**

Page 2 of 2

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

Date:

Name:

SHIP TO:

A M CASTLE METALS
4175 ROYAL DRIVE, SUITE 600
KENNESAW, GA 30144

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

SOLD TO:

AM CASTLE & CO- SOLD TO
1420 KENSINGTON RD
SUITE 220
OAK BROOK, IL 60523

Serial Number

4375600

CUSTOMER PO NUMBER: 323643		WORK PACKAGE:		CUSTOMER PART NUMBER: 752237		SHIP RUN/LOAD: 103205/13		GOV'T CONTRACT NUMBER:		
KAISER ORDER NO: 1188694		LINE ITEM: 1	SHIP DATE: 14-MAY-2015		ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: KaiserSelect Plate		
WEIGHT SHIPPED: 2860 LB		QUANTITY: 2 PCS EST.		TRUCK B/L #: 2053904		GAUGE: 2.0000 IN (50.8000 MM)		DIAMETER/WIDTH: 48.500 IN (1231.9 MM)		LENGTH: 144.500 IN (3670.3 MM)

MHU 1890034: LOT 775369A2: 1 pieces;

MHU 1890038: LOT 775367A6: 1 pieces;

DAS
14
9-89

15/09/29

Certified Specifications

MAY 21 2015



AMS 4078/RevJ
ASTM B 209/Rev14
BSS 7055/RevB
DPS 4.713/RevAK
MMS 159/RevT

AMS-QQ-A-250/12/RevA
ASTM B 594/Rev13
CMMP 025/RevU
GAMPS 9101/RevB/AmdSCN1
PS 21211/RevM

AMS-STD-2154/RevA
BAC 5439/RevJ
CSTI 006/RevE
GSS16100/RevG/Amd1

Test Code: 4297

Test Results

Lot: 775367A6 Cast 786 Drop 16 Ingot 4 Parent Lot: 131033B3 Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	71.4 : 71.9 (492 : 496)	60.5 : 61.0 (417 : 421)	12.1 : 13.0

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS :	40.8 Min	42.0 Max
(MS/M) :	23.7 Min	24.4 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.08	0.18	1.5	0.06	2.4	0.19	5.7	0.03	0.01	0.01	TOT 0.05



Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4375600

Lot: 775369A2 Cast 786 Drop 13 Ingot 5 Parent Lot: 131027B5 Melted in USA

(ASTM E8/B557)
(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	69.5 : 71.0 (479 : 490)	58.7 : 61.1 (405 : 421)	12.5 : 13.0

(ASTM E1004)
(EN 2004-1)
Conductivity %IACS : 42.1 Min 42.1 Max
(MS/M) : 24.4 Min 24.4 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.08	0.17	1.4	0.03	2.4	0.20	5.8	0.03	0.01	0.01	TOT 0.05

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075												
MIN(wt%)	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

ORDER COMMENTS

AMC CA-15413A R 7
AMS 4078,AMS QQ-A-250/12,AMS STD-2154,A
STM B209,ASTM B594,BS
S 7055,CMMP 025,CSTI 006,DPS 4.713,GAMP
S 9101,MMS 159,PS 212

11

TEST NOTES

Metal represented by this test report was 100% immersion
ultrasonically tested from one side with 3mm dead zones top
and bottom and meets the Class A and Class B requirements of
all specifications referenced on this test report. No
surface marking of sonic indications is performed.



Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4375600

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser), is ISO 9001:2008/AS9100C certified and hereby certifies that all material shipped under this order:

- * has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements.
- * was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content.
- * has been thermally processed in compliance with AMS 2772, where applicable.
- * is mercury free, within the limits of detection of ASTM E1251 (≤ 1 ppm).
- * is in compliance with RoHS 2, European Union Directive 2011/65/EU.
- * is in compliance with and regularly monitors any updates to the European Chemical Agency, ECHA, REACH regulations, (EC) n°1907/2006.
- * is free of Conflict Minerals, as defined in Section 15.2 of the Dodd-Frank Act.

Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.

JAMES HEMENWAY, LABORATORIES SUPERVISOR

**Castle Metals®**

A. M. Castle & Co. (Canada) Inc.

COMMERCIAL INVOICE

Please Ship Confirm

Ship From:A. M. Castle & Co. (Canada)
Inc.
4175 Royal Drive Suite 600
Kennesaw GA, 30144 US**Remit To:**A.M. CASTLE & CO.
(CANADA) INC.
c/o 310211
P. O. BOX 578 STN M
CALGARY, AB T2P 2J2**Shipping Mark:****Delivery Number:**

120180496

Order No.

4050963

Date Shipped**Due Date****Payment Terms****Acct No**

50676

Customer P.O. No

29713

Terms**SOLD TO:**

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7CANADA**SHIP TO**

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7CANADA**DELIVER TO**

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7CANADA**VAT:****Contract No.****BOL #:** Please Ship Confirm**Shipped Via:****Freight/INCO Terms:** Paid HAWKESBURY ON K6A 1K7 Canada

Ln#	Ordering Information	Shipping Cost / UOM	Amount
1	Purchase Order #: 29713 Order #: 4050963 Item #: 752237.MO Line #: 1 Ordered: 20 PCS Item Description: 2.0000.PL.7075.T7351.ALUMINUM.USH.48.5000.144.5000 Cutting Description: CUT RECTANGLE TO 6.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 7.875")) X 7.875 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 7.875")) Process Description: - ALUMINUM PLATE SAW Customer Part Number: D6101-003 Heat Number 775367A6 Country of Origin US Tariff Code: 7606123030 Specifications: AMS-QQ-A-250/12	Shipped Weight: 203.22LBS Shipped Qty: 20 PCS Unit Price: 39.45 / PCS Export License NLR ECCN EAR99 ITAR N/A	789.00

Line Total: 789.00**Taxes:** 102.57**Invoice Total:** 891.57**Remit to Currency:** USD



Castle Metals®

A. M. Castle & Co. (Canada) Inc.

Commercial Invoice Summary

Number: 4050963-1-

BOL Number:

Delivery Nbr: 120180496

Combined Invoice Total:

Total Extended Line Amount	789.00
Total Tax Amount	102.57
Grand Total	891.57

A.M. Castle & Co. hereby certify this invoice to be true and correct in all particulars

Signature

S. Henderson



Packing Info:

Qty	Packaging Description	Net Weight	Tare Weight	Gross Weight
1	SKID 51 X 40 X 8	203 LBS	175 LBS	378 LBS



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29713**

Purchase Order Date 9/8/2015

PO Print Date 9/8/2015

Page Number 1 of 3

Order From :

VU-MET002

Ship To : DART AEROSPACE LTD

METAUX CASTLE
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W 0E9
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FOCUS

Contact Name

Buyer

Chantal Lavoie

Vendor Phone

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

USD

Ship Via:

Yours ppd

FOB

Destination-Collect

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D6101-003P AS PER DWG D6101 REV. B B136764 SIZE: 7.875" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 7.875" LENGHT MATERIAL: 7075-T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	7075-T7351 2X6.25X7.875	9/24/2015 Yes 9/24/2015		20.00 Each 15/9/28 JL	\$39.45	\$789.00
Line Total:							\$789.00
2	D6101-005P AS PER DWG.D6101 REV.B B136765 SIZE: 5.00" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG 5.00"" LENGHT MATERIAL: 7075-T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	7075-T7351 8.25X5.0X2.5	9/24/2015 Yes 9/24/2015		20.00 Each ✓ SP/15-09-23	\$42.75	\$855.00

Note:

9/8/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29713**

Purchase Order Date 9/8/2015

PO Print Date 9/8/2015

Page Number 2 of 3

Order From :

METAUX CASTLE
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W 0E9
CANADA

VU-MET002

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via:

Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

					Line Total:	\$855.00
3	D6101-007P ✓	7075-T7351 8.25X7.75X2.5	9/24/2015	40.00 ✓	\$61.10	\$2,444.00
				Yes	Each	
				9/24/2015		

AS PER DWG D6101 REV. B

B136766

MATERIAL: 7075-T7351 (QQ-A-250/12)

SIZE: 7.750" X 8.250" X 2.50" THICK

GRAIN DIRECTION ALONG: 7.750" LENGTH

TOLERANCE AS PER QUOTE +.030"/-.000"

					Line Total:	\$2,444.00
4	D6101-017P ✓	ALUM BILLET	9/24/2015	10.00 ✓	\$64.75	\$647.50
				Yes	Each	
				9/24/2015		

AS PER DWG D6101 REV. B

B136767

SIZE: 6.350" X 6.250" X 2.250" THICK

GRAIN DIRECTION ALONG 6.350" LENGTH

MATERIAL: 7075-T7351 QQ-A-250/12

TOLERANCE AS PER QUOTE +.030"/-.000"

2015-09-23

Line Total: \$647.50

Note:

9/8/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29713**

Purchase Order Date 9/8/2015

PO Print Date 9/8/2015

Page Number 3 of 3

Order From :

METAUUX CASTLE
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W OE9
CANADA

VU-MET002

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

5	71401-45	PROCUREMENT QUALITY CLAUSES	9/24/2015	1.00	✓	\$0.00	\$0.00
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No

9/24/2015

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

8015-09-23

Line Total:

\$0.00

PO Total:

\$4,735.50

CL H

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 9/8/2015

BON DE CONNAISSANCE NOMINATIF A L'ORIGINAL - NON NEGOCIABLE STRAIGHT BILL OF LADING - SHORT FORM ORIGINAL - NOT NEGOTIABLE REÇU, Sujet aux classifications et tarifs en vigueur à la date d'émission du présent bon de connaissance RECEIVED, Subject to the classification and tariffs in effect on the date of issue of this Bill of Lading Le bien décrit plus bas, en bon état apparent, exception faite comme noté (le contenu et la condition du contenu de l'emballage inconnus), marqué, consigné et destiné comme indiqué ci-après, que le dit transporteur (le mot « transporteur » signifiant dans ce contrat toute personne ou société en possession du bien en vertu de ce contrat) accepte de le transporter à l'endroit habituel de livraison de ladite destination, si sur sa route, ou sinon de le livrer à un autre transporteur en route vers ladite destination. Il est mutuellement accepté, par chacun des transporteurs de toute ou n'importe quel dit bien, en totalité ou en partie de la route à destination, et par chaque partie intéressée par la totalité ou n'importe quelle partie du bien à n'importe quel moment, que chaque service à être exécuté tel que décrit ci-après est sujet à toutes les modalités et conditions générales du bon de connaissance nominatif « Uniform Domestic Straight Bill of Lading » présenté (1) dans la Classification uniforme de transport en vigueur à la date des présentes, s'il s'agit d'une expédition par voie ferroviaire ou par voie marine, ou (2) dans la classification ou le tarif applicable au transporteur motorisé s'il s'agit d'une expédition par véhicule motorisé. The property described below, in apparent good order, except as noted (contents and condition of contents of packages unknown), marked, consigned, and destined as indicated below, which said carrier (the word carrier being understood throughout this contract as meaning any person or corporation in possession of the property under the contract) agrees to carry to its usual place of delivery at said destination, if on its route, otherwise to deliver to another carrier on the route to said destination. It is mutually agreed, as to each carrier of all or any said property over all or any portion of said route to destination, and as to each party at any time interested in all or any of said property, that every service to be performed hereunder shall be subject to all the terms and conditions of the Uniform Domestic Straight Bill of Lading set forth (1) in Uniform Freight Classification in effect on the date hereof, if this is a rail or water shipment, or (2) in the applicable motor carrier classification or tariff if this is a motor carrier shipment.		No du livreur / Shipper No.: 2734860-2 De - A / FROM AT: A. M. Castle & Co. 835-SELKIRK AVENUE POINTE CLAIRE QC H9R 3S2 CAN d expédition / Ship Date: 23-SEP-2015 MANITOULIN TRANSPORT 1-800-265-1485  2 2 2 1 8 1 5 3
Consigné à / Consigned To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY ON K6A 1K7 CAN	Directives de livraison / Delivery instructions: TOUS LES CHARGEMENT DOIVENT ÊTRE COUVERT. LA LISTE D'EMBALAGE DE LIVRAISON ET LES RAPPORTS DE TEST OU CONSIGNATAIRES REFUSERONT. ALL LOADS MUST BE TARPED. DELIVER PACKING LIST AND TEST REPORTS OR CONSIGNEE WILL REFUSE.	Modalités de paiement / Payment Terms: Prepaid REMETTRE LES FACTURES DE TRANSPORT À / REMIT FREIGHT INVOICES TO: RayTrans Management, Inc. PO Box 1210 Washington PA 15301
Nom du Transporteur / Carrier Name: MANITOULIN	Couverture d'assurance additionnelle / Additional Insurance Coverage: La valeur accepté ou déclaré de la propriété ci bas spécifiée par le transporteur n'excède pas : The agreed or declare value for the property is hereby specifically stated by the shipper to be not exceeding: _____ par / per _____	

Détail de livraison / Shipment Breakdown:

Quantité / Quantity	Emballage / Packaging	Classe / Class	Commodity
1	SKID	FAK 50	Metal Product

Poids du Chargement / Shipment Weights:

Produit / Product	203 LBS
Dunnage	175 LBS
Gross	378 LBS

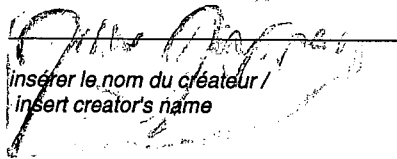
ORDER DETAIL:

Bon de commande du client / Customer PO	No de commande du client / Sales Order No.	No de ligne / Line No.	No. d'Item Castle / Castle Item No.	Quantité livrée / Quantity Shipped	Castle UOM
29713	4050963	1	4050963*1*1	20	PCS

Sujet à la section 7 des Conditions générales du Bon de connaissance applicable. Si cette expédition est livrée au consignataire sans recourir à l'expéditeur, l'expéditeur doit signer les déclarations suivantes. Subject to Section 7 of Conditions of applicable bill of Lading. If this shipment is to be delivered to the consignee without recourse to the consignor, the consignor shall sign the following statements. Le transporteur ne doit pas livrer ce chargement sans avoir acquitté les frais de transport et les charges légales. The carrier shall not make delivery of this shipment without payment of freight and all other lawful charges. CETTE EXPÉDITION DOIT ÊTRE REÇUE ET TRANSPORTÉE CONFORMÉMENT À TOUTES LES MODALITÉS ET CONDITIONS GÉNÉRALES DU BON DE CONNAISSANCE COMPAGNIES DE NAVIGATION. THIS SHIPMENT IS TO BE TENDER RECEIVED AND TO BE CARRIED SUBJECT TO ALL TERMS AND CONDITIONS OF THE STEAMSHIP COMPANIES CURRENT FORM BILL OF LADING CE DOCUMENT CERTIFIE QUE LES ARTICLES MENTIONNÉS CI-DESSUS SONT PROPREMENT CLASSIFIÉS, DÉCRITS, EMBALLÉS, MARQUÉS ET IDENTIFIÉS, ET SONT EN ÉTAT D'ÊTRE TRANSPORTÉS CONFORMÉMENT AUX RÈGLEMENTS DU MINISTÈRE DES TRANSPORTS. THIS IS TO CERTIFY THAT THE ABOVE NAMED ARTICLES ARE PROPERLY CLASSIFIED, DESCRIBED, PACKAGED, MARKED AND LABELED, AND ARE IN PROPER CONDITION FOR TRANSPORTATION ACCORDING TO THE APPLICABLE REGULATIONS OF THE DEPARTMENT OF TRANSPORTATION.	Si l'expédition se déplace entre deux ports par un transporteur par voie maritime, la loi exige que le bon de connaissance stipule s'il s'agit « du poids du transporteur ou de l'expéditeur ». NOTE : Là où la charge est en fonction de la valeur, les expéditeurs doivent déclarer spécifiquement par écrit la valeur du bien acceptée ou déclarée. If the shipment moves between two ports by a carrier by water, the law requires that the bill of lading shall state whether it is "carrier's or shipper's weight." NOTE: Where the rate is dependent on value, the shippers are required to state specifically in writing the agreed or declared value of the property. L'expéditeur déclare spécifiquement que la valeur acceptée ou déclarée du bien ne dépasse pas. The agreed or declared value of the property is hereby specifically stated by the shipper to be not exceeding Le client est responsable de tous les documents d'expédition et de se conformer à toutes les lois canadiennes et américaines incluant, mais sans s'y limiter, les lois et règlements américains et canadiens relatifs à l'exportation. Customer is responsible for all shipping documents and compliance with United States and Canadian laws, including but not limited to U.S. and Canadian Export laws and regulations.
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MANITOULIN

EXPÉDITEUR - PAR /
SHIPPER, PER:


insérer le nom du créateur /
insert creator's name

PREUVE DE LIVRAISON /
PROOF OF DELIVERY:

Signature / Date

Par /
Per

Signature du conducteur /

Date

Driver's Signature

Name

Please Print Name Here

Toutes les pages doivent être signées/ All pages must be signed

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6101-003
DATE: 15/09/29

PO / BATCH NO: 29713/136764

MATERIAL CERT REC'D: yes
QUANTITY RECEIVED: 20
QUANTITY INSPECTED: 20
QUANTITY REJECTED: _____

THICKNESS ORDERED: 7.875X6.25X2.00
THICKNESS RECEIVED: 7.875X6.25X2.00
SHEET SIZE ORDERED: _____
SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	N	
CORRECT FINISH	Y	N	
CORROSION	Y	N	
CORRECT GRAIN DIRECTION	Y	N	
CORRECT MATERIAL	Y	N	
CORRECT THICKNESS	Y	N	
PHOTO REQUIRED	Y	N	
CORRECT MATERIAL	Y	N	
CORRECT REF # TO LINK CERT	Y	N	
CORRECT MATERIAL IDENTIFICATION	Y	N	
CORRECT M# ON THE MATERIAL	Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u>	SIGNED OFF BY: _____		
DATE: <u>15/09/29</u>	DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE 2) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER